

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009133**Date Inspected:** 11-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Hong Fei, Liu Zhong An**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower/OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#10

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 3 located on PCMK NSD1-FESA4-3E/F. Welder is identified as 050041ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 10 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 040533ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 3 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 040338ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 12 located on PCMK NSD1-FESA4-3E/F. Welder is identified as 057244ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with

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the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 3 located on PCMK NSD1-FESA4-3E/F. Welder is identified as 053869ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 10 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 066401ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

FCAW welding process of weld joint 3 located on PCMK NSD1-FESA4-3D/F. Welder is identified as 057180ZPMC QC is identified as Liu Zhong An. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332-TC-P4-F-1.

BAY#11

This QA Inspector randomly observed the following work in progress.

FCAW welding process of weld joint 78 located on PCMK ESTL3-4B/K. Welder is identified as 066882 ZPMC QC is identified as Zhang Zhi Neng. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC-P4-F.

SMAW welding process of weld joint 83A/B located on ESTL3-4B/K. Welder is identified as 049099ZPMC QC is identified as Mao Bin Bin. The welding variables recorded by QC appeared to comply with the WPS-345-SMAW-4G (4F) Repair.

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This QA Inspector randomly observed the following work in progress.

OBG segment 1BE

This QA Inspector observed ZPMC personnel performing grinding for the cope hole repair at PP8.5. The cope hole existing the weld joint between Deck panel diaphragm floor beam flange.

OBG segment 2AW

This QA Inspector observed ZPMC personnel performing grinding for the cope hole repair at PP13. The cope hole existing the weld joint between floor beam to Bottom panel

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

Summary of Conversations:

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No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 13482570045, who represents the Office of Structural Materials for your project.

Inspected By:	Utekar,Shrikant	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
